

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002646**Date Inspected:** 14-May-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector Sherri Brannon arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China to periodically monitor welding and Quality Control (QC) functions. While on site the QA Inspector observed and/or discovered the following.

OBG/Tower Sub Assembly**Bay 1 – PMT/Deck Panel Production**

QA Inspector Brannon observed welding utilizing the dual process WPS-B-T-2342-U1 (U-rib)-3 welding procedure specification for closed rib welding of the Production Monitoring Test (PMT) #1 for Production Panel DP381-001 on closed U-rib Partial Joint Penetration (PJP) welds in Bay #1. ZPMC welding personnel performed Gantry Machine, Gas Metal Arc Welding (GMAW) for the root pass and immediately performed Gantry Machine, Submerged Arc Welding (SAW) for the cover/final pass on PMT #1, using gantry machine #1. Upon completion of the SAW pass on U-rib PJP welds on PMT #1 Visual Testing (VT) was performed on weld #1 through #6 by ZPMC personnel and was accepted then VT was verified by the Caltrans QA inspector. Ultrasonic Testing (UT) was then performed by ZPMC inspector and PMT #1 was determined to be acceptable. Macro etch samples were selected by the Caltrans QA inspector on PMT #1.

OBG/Tower Sub Assembly**Bay 1 – Deck Panel VT**

The QA inspector performed visual weld inspection to the deck panels deck panel DP490-001 welds 1 thru 6 and DP554-001 welds 6 thru 10. The QA inspector found weld discontinuities on all of the weld identified as incomplete fusion, overlap, under fill, undercut, oversize and undersize welds. Deck Panel DP490-001 and

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DP085-001 had been visual inspected by ZPMC and ABF. A hand written visual inspection report was generated on this date with all the findings.

The following digital photograph below illustrates observation of the activities being performed.



Summary of Conversations:

No relevant conversations to report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By: Brannon,Sherri

Quality Assurance Inspector

Reviewed By: Carreon,Albert

QA Reviewer